

Date: Thursday, 3/2/2006 3:07:07 PM
 User: Kim Johnston

Process Sheet

12

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : VERTICAL REFERENCE DOOR 212/412
 Job Number : 26023
 Estimate Number : 10887
 P.O. Number : N/A Part Number : D412711011
 This Issue : 3/2/2006 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : N/A
 Previous Run : 21900 Material : N/A
 Due Date : 3/20/2006 Qty: 1 Um: Each
 Written By : See comment below
 Checked & Approved By : 06.03.02
 Comment : Est Rev:A 04.09.29 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

DH 06-02-06

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

06-03-03

3.0 D412711041 Vertical Ref. Door Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-711-041 Vertical Reference Door

25672 from 5246

4.0 D412711111 Wiring Harness, 212/412



Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-711-111 Wiring Harness, 212/412

B21901

5.0 EA2046915412 Instrument Panel, 412



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412

M19150

C 206103115 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 06/03/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:07:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 26023

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

U 06-03-15

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-711-011

Location: _____

PPP Rev: _____

C 06/03/15 (1)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/15

Job Completion



U 06-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd.

Date: Friday, 23/2006 2:30:29 PM
User: Linda Laotie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 25672
 Estimate Number : 10902
 P.O. Number :
 This Issue : 2/3/2006 S.O. No. :
 Prst Rev. : NC
 First Issue : 1/30/2006 Type : PURCHASED PARTS
 Previous Run : 25671

Drawing Name : VERTICAL REFERENCE DOOR ASSEMBLY

Part Number : D412711041
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : N/A
 Material : N/A
 Due Date : 3/15/2006

Qty: 1 Um: Each

Written By :
 Checked & Approved By :
 Comment : Est Rev: A 04.08.18 New Issue KJ/DS

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING

Comment: PURCHASING

Issue P/O: 496 to Eagle Copters

Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041

Send a copy of this IPP

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES

Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door 4042375

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty	Part Number	Description	Batch
1	EB212-100L/EA20468-3	Window	4042375
1	EA20469-05	Rubber Strip	4042375
1	EA20469-06	Aluminum Strip	4040359
1	EA20469-07	Angle	4040359
1	EA20469-08	Plecard	4040359
1	EA20469-10	Rear Rib Assy	4040359
1	EA20469-11	Angle	4040359

02/02/2006 16:03 5136321053

DART-AEROS

PAGE 12

Date: Friday, 2/3/2006 2:30:30 PM
 User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25672

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description :

- | | | | |
|---|------------|------------------|-----------|
| 1 | EA20469-12 | Fwd Rib | W/O 40359 |
| 1 | EA20469-13 | Window | W/O 40359 |
| 1 | EA20469-14 | Window Retainer | W/O 40359 |
| 1 | EA20469-16 | Armrest Assy | W/O 40359 |
| 1 | EA20469-17 | Angle | W/O 40359 |
| 1 | EA20469-18 | Door Inner Skin | W/O 40359 |
| 1 | EA20469-21 | Door Cover Panel | W/O 40359 |
| 2 | EA20469-23 | Link | W/O 40359 |
| 1 | EA20469-24 | Rod | W/O 40359 |
| 1 | EA20469-25 | Arm Assy | W/O 42444 |

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3ABolt LT 05-01-5678

22 AN3-4ABolt LT 05-02-2682

24 AN3-7ABolt LT 05-02-2682

8 AN960-6L Washer LT 01-3051

90 AN960-10L Washer

34 CR3242-4-2 Rivet LT 05-01-1441

135MS20426AD3-3 Rivet LT 05-02-160

140MS20426AD4-3 Rivet 53852

25 MS20470AD3-3 Rivet LT 05-02-172

90 MS20470AD4-3 Rivet LT 05-02-170

24 MS21042L3 Nut LT 05-02-144

2 MS21042L06 Nut LT 05-02-104

13 MS21069L3 Nut Plate LT 05-02-828

8 MS21069L08 Nut Plate LT 05-02-1730

1 MS21071L3 Nut Plate LT 05-02-1463

1 MS21071L08 Nut Plate LT 05-02-1477

9 MS21075L3 Nut Plate LT 05-01-3470

2 MS24877-12 Screw LT 05-01-1731

6 MS27039-1-09 Screw LT 05-01-1740

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install
 EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

Date: Friday, 2/3/2006 2:30:30 PM
User: Linda Lacale

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25872

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description:

3.0

QC4

INSPECT 100% KITS FOR COMPLETENESS

*J. K. [Signature]*

Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 02/03/06

Job Completion

*u 06-03-15*

F A X

Date: MARCH 14/06

Number of pages including cover sheet:

To:

LINDA

Tel:

Fax:

CC:

EAGLE
COPTERS

Toll-Free: 1-800-564-6469

Tel: (403) 250-7370, Fax: (403) 250-7110

Eagle Copters Maintenance Ltd.

823 McTavish Road NE

Calgary, Alberta, Canada T2E 7G9

REMARKS:

☐ Urgent

☐ For your review

☐ Reply ASAP

☐ Please comment

*THIS IS THE DOOR BEING SHIPPED TO
ACCENT*

JASON

Date: Monday, 1/30/2006 3:43:57 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL REFERENCE DOOR ASSEMBLY
Job Number : 25672	
Estimate Number : 10902	
P.O. Number :	Part Number : D412711041
This Issue : 1/30/2006 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : N/A
Previous Run : 25671	Material : N/A
Written By :	Due Date : 3/15/2006 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 04.08.18 New Issue KJ/DS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: 497 to Eagle Copters

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES

**Comment:** Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window

1 EA20469-05 Rubber Strip

1 EA20469-06 Aluminum Strip

1 EA20469-07 Angle

1 EA20469-08 Placard

1 EA20469-10 Rear Rib Assy

1 EA20469-11 Angle

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25672

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	EA20469-12	Fwd Rib
1	EA20469-13	Window
1	EA20469-14	Window Retainer
1	EA20469-16	Armrest Assy
1	EA20469-17	Angle
1	EA20469-18	Door Inner Skin
1	EA20469-21	Door Cover Panel
2	EA20469-23	Link
1	EA20469-24	Rod
1	EA20469-25	Arm Assy

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

14	AN3-3ABolt		
22	AN3-4ABolt		
24	AN3-7ABolt		
6	AN960-6L Washer		
90	AN960-10L Washer		
34	CR3242-4-2 Rivet		
135	MS20426AD3-3 Rivet		
140	MS20426AD4-3 Rivet		
25	MS20470AD3-3 Rivet		
90	MS20470AD4-3 Rivet		
24	MS21042L3 Nut		
2	MS21042L06 Nut		
13	MS21069L3 Nut Plate		
8	MS21069L08 Nut Plate		
1	MS21071L3 Nut Plate		
1	MS21071L08 Nut Plate		
9	MS21075L3 Nut Plate		
2	MS24677-12 Screw		
6	MS27039-1-09 Screw		

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Job Number: 25672

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd.

Date: Friday, 2/3/2006 2:30:29 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	VERTICAL REFERENCE DOOR ASSEMBLY	
Job Number :	25672	Part Number :	D412711041	
Estimate Number :	10902	Drawing Number :	N/A	
P.O. Number :		Project Number :	N/A	
This Issue :	2/3/2006	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	N/A	
First Issue :	1/30/2006	Type :	PURCHASED PARTS	
Previous Run :	25671	Material :	N/A	
Written By :		Due Date :	3/15/2006	Qty: 1 Um: Each
Checked & Approved By :				
Comment :	Est Rev:A 04.08.18 New Issue KJ/DS			

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 496 to Eagle Copters

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

2.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door W/042375

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty	Part Number	Description	Batch
1	EB212-100L / EA20469-3	Window	<u>W/042375</u>
1	EA20469-05	Rubber Strip	<u>W/042375</u>
1	EA20469-06	Aluminum Strip	<u>W/040359</u>
1	EA20469-07	Angle	<u>W/040359</u>
1	EA20469-08	Placard	<u>W/040359</u>
1	EA20469-10	Rear Rib Assy	<u>W/040359</u>
1	EA20469-11	Angle	<u>W/040359</u>

Date: Friday, 2/3/2006 2:30:30 PM
 User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25672

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description:

1	EA20469-12	Fwd Rib	w/ 40359
1	EA20469-13	Window	w/ 40359
1	EA20469-14	Window Retainer	w/ 40359
1	EA20469-16	Armrest Assy	w/ 40359
1	EA20469-17	Angle	w/ 40359
1	EA20469-18	Door Inner Skin	w/ 40359
1	EA20469-21	Door Cover Panel	w/ 40359
2	EA20469-23	Link	w/ 40359
1	EA20469-24	Rod	w/ 40359
1	EA20469-25	Arm Assy	w/ 42444

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty Part Number Description Batch

14	AN3-3ABolt	KT 05-01-5078
22	AN3-4ABolt	KT 05-02268
24	AN3-7ABolt	KT 05-02268
6	AN960-6L Washer	KT 01-3251
90	AN960-10L Washer	
34	CR3242-4-2 Rivet	KT 05-017414
135	MS20426AD3-3 Rivet	KT 05-02268
140	MS20426AD4-3 Rivet	53852
25	MS20470AD3-3 Rivet	KT 05-022472
90	MS20470AD4-3 Rivet	KT 05-022472
24	MS21042L3 Nut	KT 05-02244
2	MS21042L06 Nut	KT 05-02204
13	MS21069I 3 Nut Plate	KT 05-022828
8	MS21069L08 Nut Plate	KT 05-024730
1	MS21071L3 Nut Plate	KT 05-024463
1	MS21071L08 Nut Plate	KT 05-024477
9	MS21075L3 Nut Plate	KT 05-013470
2	MS24877-12 Screw	KT 05-011931
6	MS27039-1-09 Screw	KT 05-016766

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

Date: Friday, 2/3/2006 2:30:30 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25672

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



[Signature]



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

